

Work Order ID 142353

Monday, March 07, 2016 3:53:33 PM

142353

Page 1

Item ID: PB67-43001-29 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Blade Positioner Weldment
 Start Date: 4/1/2016 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 4/29/2016 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: umf Date: 16-3-7 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-29	C								
100	Weld per dwg A/R Aluminum rod Batch: <u>131562</u>	0.00							DAS
100	Large Fab								24
Large Fab	Memo	0.04							9-89
Large Fab	***FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG. MOVEMENT OF -285 EACH SIDE OF VERTICAL, PRIOR TO WELDING***								
	1- ASSEMBLE AND WELD AS PER DWG								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS
110									43
QC	Memo	0.00							9-89
Quality Control									APR 0 7 2016

5 APR 0 5 2016

5x APR 0 7 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval

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Monday, March 07, 2016 3:53:33 PM

Page 3

150

150

Packaging

Packaging

Identify as per dwg & Stock Location M3222

0.00

Memo

0.00

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Quality Control

Memo

0.01

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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5

JUN 02 2016

6

115 JUN 03 2016

MLJ JUN 02 2016

DQA: _____ Date: _____



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Monday, March 07, 2016 3:53:32 PM

142353

PR67-43001-29

Required Qty: 5.00

Comments: IPP Rev:A 08-06-27 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-313		Manufactured	No			100	Each	6.0000	1	5		APR 06 2016	DAS 24 9-89
PR67-43001-313													
Plate									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				6					
				139269				6		5			
PB67-43001-319		Manufactured	No			100	Each	4.0000	2	10		APR 06 2016	DAS 24 9-89
PR67-43001-319													
Gusset									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				4					
				133542				4		4			
PB67-43001-337		Manufactured	No			100	Each	1.0000	2	10		APR 06 2016	DAS 24 9-89
PR67-43001-337													
Stop Plate									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				1					
				134739				1		1			

DQA: _____ Date: _____



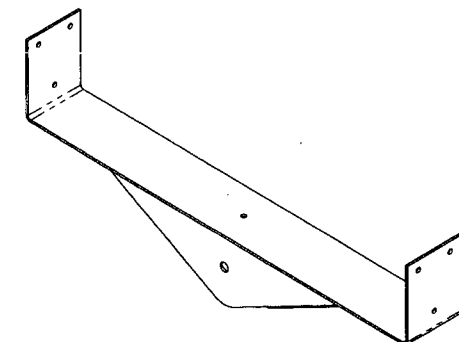
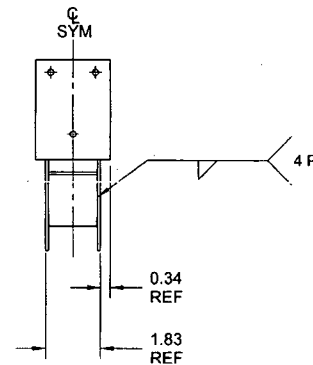
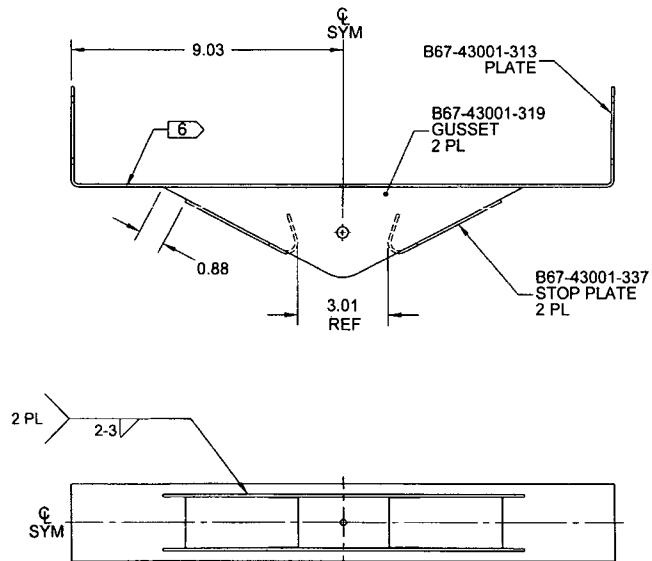
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

ITEM	QTY -29	P/N	DESCRIPTION
1	X	B67-43001-29	BLADE POSITIONER WELDMENT
3	1	B67-43001-313	PLATE
4	2	B67-43001-319	GUSSET
5	2	B67-43001-337	STOP PLATE



B67-43001-29 BLADE POSITIONER WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-29" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.01 lbs
- 8) WELDING: PER QSI 004

RELEASED
2009-09-24

C	REDRAWN PREMIER AVIATION DRAWING JAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 40 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.24
REV.	DESCRIPTION	BY	DATE	
DESIGN	RW			
DRAWN				
CHECKED	AS			
MFG. APPR.				
APPROVED				
DE APPR.	N/A			
DATE	09.06.24			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
B67-43001-29

REV. C

SHEET 1 OF 1

TITLE
BLADE POSITIONER WELDMENT

NTS

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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				Lead hand / Supervisor Approval Verification	
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